

shop 28/01

Dart Aerospace Ltd.

File: Tuesday, 20/01/2009 2:39:57 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TAILBOOM MOUNT KIT
Job Number	: 44965		
Estimate Number	: 13735		
P.O. Number	:	Part Number	: D412786015
This Issue	: 20/01/2009	S.O. No. :	Drawing Number : D412-786-1 PRELIM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Type	: SMALL /MED FAB
Previous Run	:	Drawing Revision	: PRELIM
Written By	:	Material	:
Checked & Approved By	:	Due Date	: 27/01/2009
Comment	: Est Rev:A 09-01-19 as per prelim issue DD verified by:EC		

POSITIVE
RECALL

Qty: 4 Um: Each

Additional Product

Job Number:



PRELIMINARY ISSUE

Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-786-015 CHG001

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D3866041 Mount



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mount

batch: 44950 x2

4.0 D3866043 Tailboom Mount



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Tailboom Mount

batch: B44953 x2

5.0 MS21042L3 Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Nut

batch: M108816

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Drawing Name: TAILBOOM MOUNT KIT

Job Number: 44965

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS27039111

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Screw

batch: M9662

7.0

NAS1149D0332J

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Washer

batch: M110625 (40X)

M110233 (56X)

09/01/27 (4)

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

ENGINEERING APPROVAL

09.01.28

09.01.28

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-786-015

Location: _____

PPP Rev: _____

44949

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

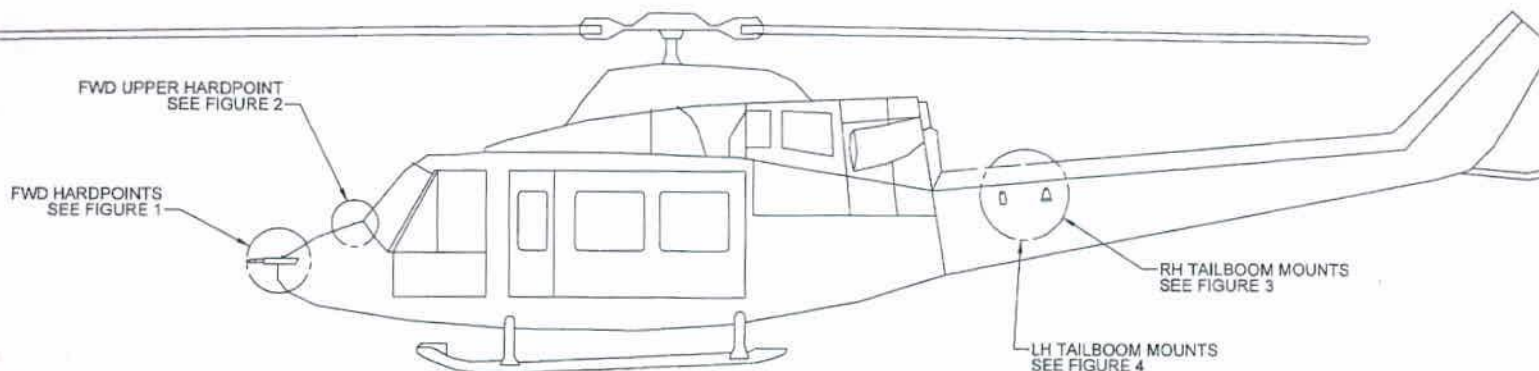
09/02/17

Job Completion



POSITIVE RECALL
EFFECTIVE 09.01.20 AUTH W
RELEASED 1 DATE 09.02.17

MF 09-01-28



D412-786-011 HARDPOINT KIT

QTY -011	QTY -013	QTY -015	PART NUMBER	DESCRIPTION
X			D412-786-011	HARDPOINT KIT
1	X		D412-786-013	FWD HARDPOINT KIT
1		X	D412-786-015	TAILBOOM MOUNT KIT
		1	D3866-041	TAILBOOM MOUNT
		2	D3866-043	TAILBOOM MOUNT
	1		D3870-041	FWD LH HARDPOINT
	1		D3870-042	FWD RH HARDPOINT
	1		D3870-5	FWD UPPER HARDPOINT
	1		D3871-1	DOUBLER
	1		D3871-2	DOUBLER
	10	12	MS21042L3	NUT
	8	12	MS27039-1-11	SCREW
	1		MS27039-1-12	SCREW
	1		MS27039-1-14	SCREW
	10	24	NAS1149D0332J	WASHER

INSTALLATION	WEIGHT	LONGITUDINAL		LATERAL	
		ARM	MOMENT	ARM	MOMENT
D412-786-011 HARDPOINT KIT	0.58 LBS 0.22 KG	164.67 IN 4.18 M	95.51 IN 0.92 KG-M	-1.25 IN -0.03 M	-0.73 IN-LB -0.007 KG-M
D412-786-013 FWD HARDPOINT KIT	0.22 LBS 0.08 KG	-13.55 IN -0.34 M	-2.98 IN-LB 0.03 KG-M	2.36 IN 0.06 M	0.52 IN-LB 0.005 KG-M
D412-786-015 TAILBOOM MOUNT KIT	0.36 LBS 0.13 KG	273.58 IN 6.95 M	98.49 IN-LB 0.90 KG-M	-3.47 IN -0.09 M	-1.25 IN-LB -0.01 KG-M

RELEASED
07/04/99

NOTES:

- 1) D412-786-011 HARDPOINT KIT REQUIRED ON 412/412EP AIRCRAFT UTILIZING D412-695-011 BLADE FOLDING KIT WHERE WIRE STRIKE COMPATIBILITY IS REQUIRED
- 2) TOUCH UP DRILLED HOLES WITH ALODINE PER THE AIRCRAFT MAINTENANCE MANUAL
- 3) TORQUE FASTENERS AS FOLLOWS: 10-32; 20-25 IN-LBS
- 4) PRIME AND PAINT HARDPOINTS TO MATCH AIRCRAFT PAINT SCHEME PER AIRCRAFT MAINTENANCE MANUAL

A	NEW ISSUE	BY	09.01.14
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG APPR.	N/A		
APPROVED			
DE APPR.			
DATE	09.01.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D412-786-1** REV. A
SHEET 1 OF 5

TITLE **HARDPOINT KIT INSTALL** SCALE NTS

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